

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007588**Date Inspected:** 29-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A
Component:	OBG and TOWER Components	

Bridge No: 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

BAY 3**Ultrasonic Testing**

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designations reviewed are as follows:

1. FB205 – 026 – 006
2. FB205 – 027 – 005
3. FB204 – 027 – 040
4. FB204 – 027 – 046
5. FB204 – 026 – 034
6. FB204 – 026 – 040

Green Tags

The following green tags issued for OBG components after completing the NDT requirements are:

1. FB004 – 043 – Green Tag # 009585
2. FB003 – 196 – Green Tag # 009589

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- 3. FB003 – 182 – Green Tag # 009590
- 4. FB003 – 188 – Green Tag # 009591
- 5. FB003 – 199 – Green Tag # 009592
- 6. FB003 – 201 – Green Tag # 009593

BAY 5

This QA Inspector observed the following work in progress:

SMAW process Tack welding of weld joint #016 located on Bike Path BK001 – 021. Welder is identified as 216423. ZPMC QC is identified as Xu Hong Min. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

BAY 6

This QA Inspector observed the following work in progress:

SAW process welding of weld joint #016 – 1A located on ND1 – SA658 – 65M. Welder is identified as 054458. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – TC – U5 – S – 1.

SMAW process welding of weld joint #16 located on NSD1 – DPSA4 – 13B/B. Welder is identified as 066459. ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3312 – Tc – P5.

SMAW process Tack welding of weld joint #4 – 1B located on ND1 – SA658 – 77M. Welder is identified as 037840. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

SMAW process welding of weld joint #17 located on NSD1 – DPSA4 – 13B/B. Welder is identified as 068918. ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3312 – Tc – P5.

SAW process welding of weld joint #7 – 1A located on ND1 – SA658 – 53M. Welder is identified as 046830. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – TC – U5 – S – 1.

SMAW process welding of weld joint #12 located on NSD1 – DPSA4 – 13B/B. Welder is identified as 066456. ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3312 – Tc – P5.

SMAW process Tack welding of weld joint #9 – 1B located on ND1 – SA658 – 77M. Welder is identified as 067656. ZPMC QC is identified as Wang Xiao Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3211 – Tc – U5b – 1.

SMAW process welding of weld joint #13 located on NSD1 – DPSA4 – 13B/B. Welder is identified as 037779.

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ZPMC QC is identified as Zou Liu Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3312 – Tc – P5.

BAY 7

This QA Inspector observed the following work in progress:

SMAW process welding of weld joint #071 located on SP3013 – 001. Welder is identified as 051786. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

SMAW process welding of weld joint #044 located on SP3013 – 001. Welder is identified as 203206. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 (FCM) – 1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
